

5/13

Split

DART AEROSPACE LTD		Work Order:	22791A
Description: Doubler		Part Number:	D3302-1
Dwg: D3302 Rev. A ^{04.11.25} B ^{04.12.16}		Qty:	10 20
		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Note: To be made in multiples of 10	HA	05.03.22	20
2	MV	Cut blank: 12.900" x 7.850" ^{13.150"} Material: 6061-T6 (QQ-A-250/11) 0.063" thick (M6061T6S.063) Identify for D3302-1 Batch: <u>M16455</u>	SA	05.03.22	20
3	MV	Machine as per Folio FA450 and Dwg D3302 Stack of 10 Identify as D3302-1	EP	05/03/23	20
4	QC2	Inspect parts as they come off the CNC machine	EP	05/03/23	20
5	QC8	Second check	rm	05/03/23	20
6	GA	Deburr break all unmarked sharp edges 0.005 to 0.010	J	05-03-30	10
7	GB	Form as per Dwg D3302	J	05-03-30	10
8	QC5	Inspect work to Step 7	DA	05/03/30	10
9	FP	Chemical Conversion Coat as per QSI 005 4.1	MM	05 03 30	10
10	QC3	Inspect Chemical Conversion Coat	DA	05 03 30	10
11	ST	Identify and Stock	KD	05/03/31	10
12	AC	Cost / part 28.57 ^{40.36}	515	05-04-01	10
13	DC	Close W/O 28.57 ^{40.39} Inspect Level 21	HA	05.04.05	10

Rev	Date	Change	Revised By	Approved
A	04.09.02	New issue	KJ/JLM	

RELEASED
Jul 04 09 05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

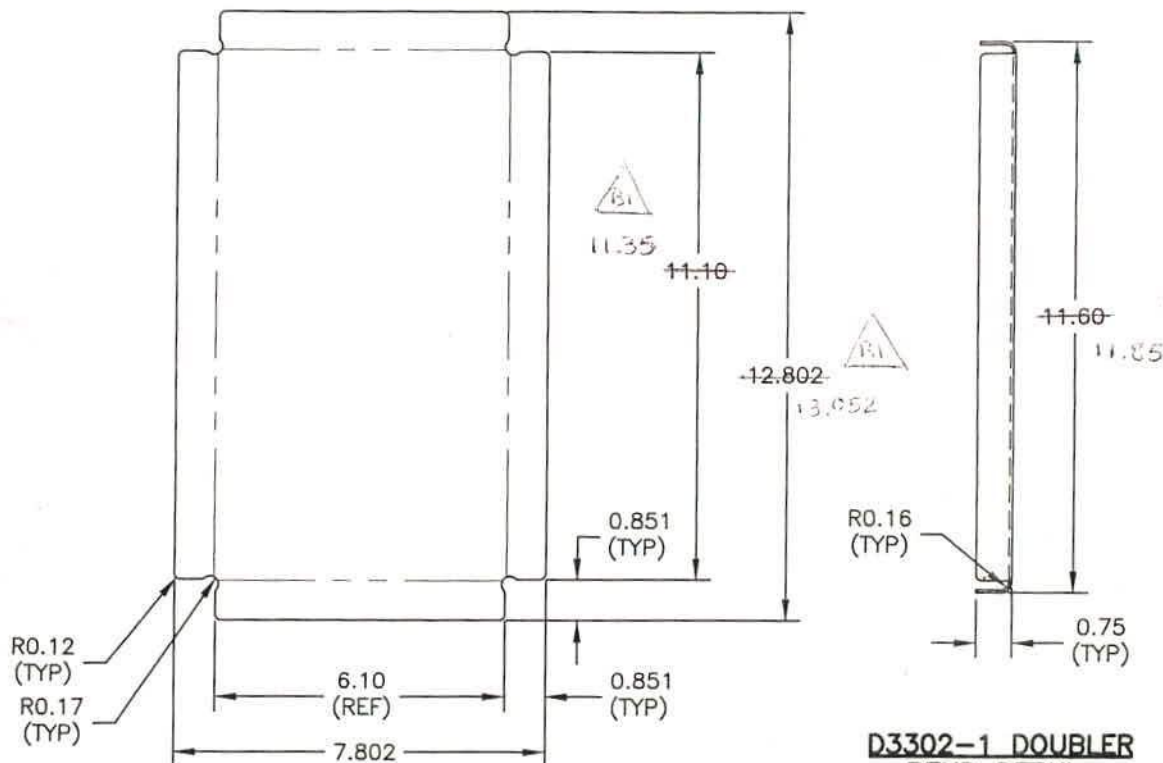
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



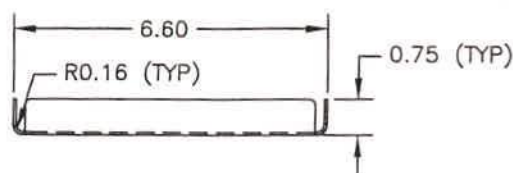
DESIGN F#	DRAWN BY F#	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED F#	APPROVED F#	DRAWING NO. D3302	REV. B SHEET 1 OF 4
DATE 04.11.18		TITLE DOUBLER	SCALE 1:4
A	04.07.06	NEW ISSUE	
B	04.11.18	REMOVE HOLES	
B1	04.12.15	ADDED 0.25" TO THE LENGTH FOR -1/-3	
B2	05.03.21	7.30 WAS 7.34; 8.997 WAS 9.042; 7.75 WAS 7.84 FOR D3302-3	

RELEASED
04.11.23



D3302-1 FLAT PATTERN

D3302-1 DOUBLER
BEND DETAIL



D3302-1 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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ENGINEERING

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WORK ORDER

NO. 22791

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Mar 21, 2005
10:23 am

Work Order No : 0022791
Project Name : D3302-1
Project For : WK513
Work Order Type : Main
Main WO Number :
House Part Number : D3302-1
Description : Doubler
Manufactured : Yes
Amount Req'd : 20
Amount Done : 0
Start Date : 03-21-05
Est Finish Date : 03-30-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Order Entry No :
OE Value : 0.00

Est Mark Up : 0.000%
Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00